

Work Order ID 67219

Friday, March 11, 2011 8:46:51 AM



Page 1

Item ID: D212-664-101TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 3/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]* Date: 11-03-11 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-141	Rev D								

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

OK 11/03/22

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA113
2-Turn first side as per Folio FA113
3-File down transition lines smooth.

1 *0*

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

OK 11/03/22

Quality Control

1 *0*

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

OK 11/03/22

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA113
2-File down transition lines smooth.
3-Remove sand and plugs

1 *0*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

AMK 11/03/22

1 0

Quality Control

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

11/3/22

1 0

Quality Control

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

1 JB 11/03/22

Hand Finishing Crosstubes

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

DP

11-3-22

Memo

0.00

170



Packaging

Packaging

Packaging

0.00

DP

11-3-22

Memo

Identify and Stock in kanban rack
Location: 46

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

11/3/23 JF

Memo

0.00

MF
11-03-22

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Picklist Print

Friday, March 11, 2011 8:46:57 AM

Page 1

Work Order ID: 67219

Parent Item: D212-664-101TRN

Parent Item Name: Crosstube Turning Detail




Start Date: 3/11/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed Polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6005-128 		Manufactured	No			120	Each	21.0000	1	1		11.3.18	

Crosstube Material

Location

Loc Qty

Loc Code

LG

21

53593

4

57911

17

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DART AEROSPACE LTD	Work Order:	67219
Description: Crosstube Assembly (205/212/412 High Fwd)	Part Number:	D212-664-141
Inspection Dwg: D212-664-141 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	200	✓		Vern H/L-7
	R0.063	+/-0.010	R.063	✓		Rad-gage
	2.740	+0.005/-0.000	2.745	✓		Vern H/L-7
	5.097	+/-0.030	5.090	✓		"
	2.304	+0.005/-0.000	2.308	✓		"
	2.340	+0.005/-0.000	2.343	✓		"
	2.398	+0.005/-0.000	2.403	✓		"
	2.448	+0.005/-0.000	2.453	✓		"
	2.498	+0.005/-0.000	2.503	✓		"
	2.549	+0.005/-0.000	2.554	✓		"
	2.599	+0.005/-0.000	2.604	✓		"
	2.671	+0.005/-0.000	2.675	✓		"
	2.701	+0.005/-0.000	2.704	✓		"
SIDE B	0.200	+/-0.010	200	✓		Vern H/L-7
	R0.063	+/-0.010	R.063	✓		Rad-gage
	2.740	+0.005/-0.000	2.744	✓		Vern H/L-7
	5.097	+/-0.030	5.095	✓		"
	2.304	+0.005/-0.000	2.308	✓		"
	2.340	+0.005/-0.000	2.343	✓		"
	2.398	+0.005/-0.000	2.403	✓		"
	2.448	+0.005/-0.000	2.453	✓		"
	2.498	+0.005/-0.000	2.503	✓		"
	2.549	+0.005/-0.000	2.554	✓		"
	2.599	+0.005/-0.000	2.604	✓		"
	2.671	+0.005/-0.000	2.675	✓		"
	2.701	+0.005/-0.000	2.704	✓		"
	126.514	+/-0.020	126.530	✓		M-tape

Measured by:	Onr	Audited by:	SA	Prototype Approval:	N/A
Date:	11/03/22	Date:	11/15/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
C	07.05.28	Dwg Rev updated	KJ/JLM	
D	10.02.02	Dimension 126.514 was 126.51	KJ	

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8 7 6 5 4 3 2 1



Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS
- WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS
6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE
SUPPORT.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND
MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT
HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67219

BD 11-03-11

RELEASED
2009-10-29

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>PH</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>PH</i>	D212-664-141	SHEET 1 OF 4
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	XTUBE ASSY (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

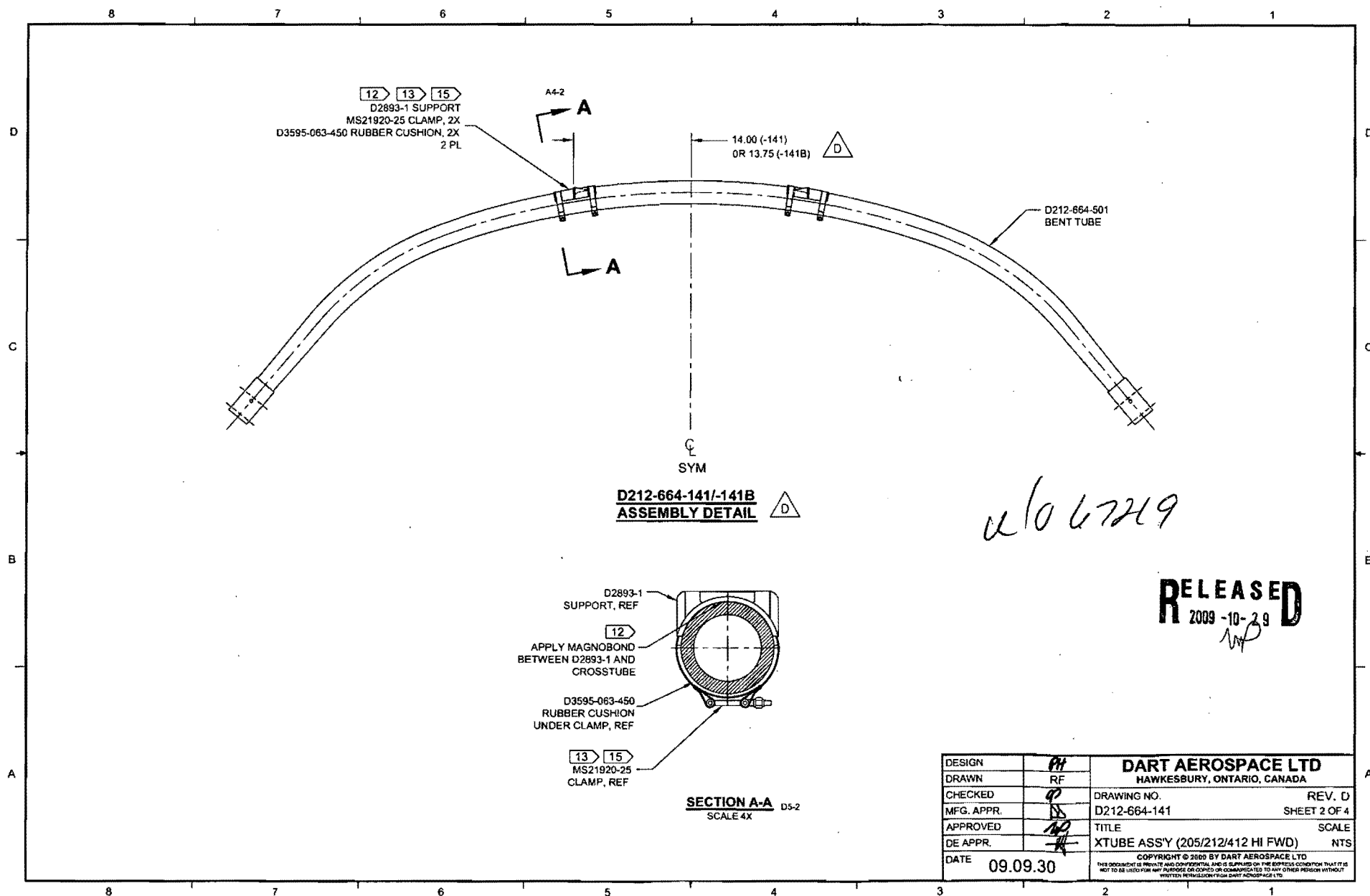
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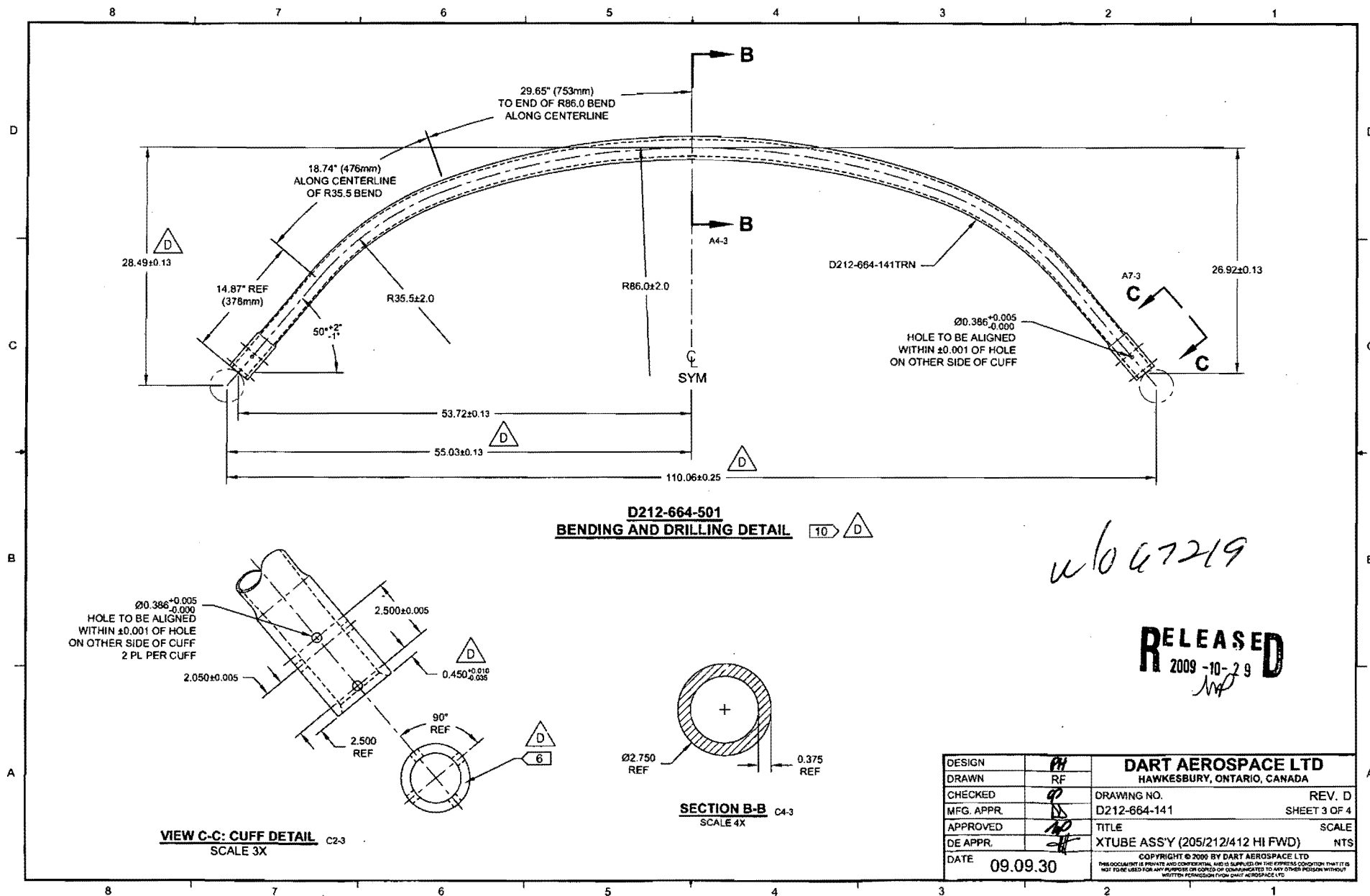
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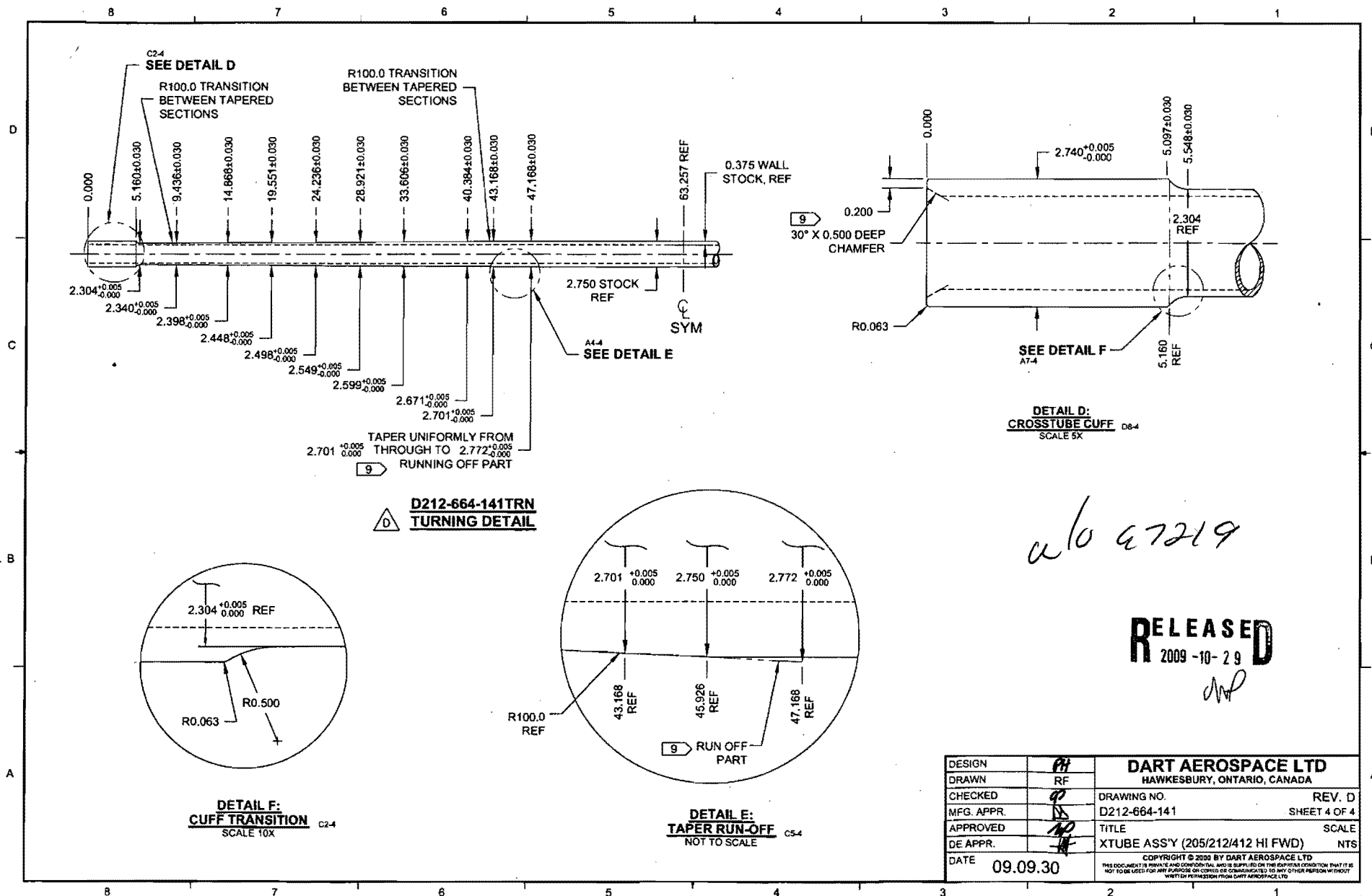
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Dart Aerospace Ltd

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